

Date: Tuesday, 1/9/2007 4:06:46 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
 Job Number : 30215
 Estimate Number : 10534
 P.O. Number : *N/A* Part Number : D2574
 This Issue : 1/9/2007 S.O. No. : *N/A* Drawing Number : D2574 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : E
 Previous Run : 30097 Material : *N/A*
 Written By : *[Signature]* Due Date : 1/30/2007 Qty: 12 Um: Each
 Checked & Approved By : *[Signature]* 02.01.09
 Comment : Est Rev: I As Per RevE 06-01-27 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2574

Ensure that grain is along 5.00" length

Batch No: *325351*

x12

E 07/01/04 / J.F.

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. *330215* Double check by: *J.F.*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

E 07/01/18

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

J.F. 07/01/18

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

E 07/01/18

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/25
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 1/9/2007 4:06:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 30215

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 07/01/22 12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JS/

07/01/22 12

7.0

POWDER COATING

POWDER COATING



M103141



(12X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

mk/yf

07/01/24

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/01/24

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 344

07/01/24 (12)

07/01/24

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

07/01/25

Job Completion



07-01-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|---|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 30215 |
| Description: Saddle, Aft Inboard | Part Number: | D2574 |
| Inspection Dwg: D2574 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | DT8682 | 0.440 | 0.439 | 0.440 | 0.439 | | |
| B | 1.745 | 1.755 | | 1.752 | 1.752 | 1.753 | 1.752 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.752 | 1.752 | 1.753 | 1.752 | | |
| E | 7.990 | 8.010 | | 7.999 | 8.004 | 8.000 | 8.004 | | |
| F | 0.490 | 0.510 | | 0.493 | 0.493 | 0.491 | 0.493 | | |
| G | 0.257 | 0.262 | DT8683 | 0.258 | 0.260 | 0.258 | 0.258 | | |
| H | 0.375 | 0.380 | DT8684 | 0.376 | 0.376 | 0.376 | 0.376 | | |
| I | 0.490 | 0.510 | | 0.500 | 0.500 | 0.498 | 0.500 | | |
| J | 1.174 | 1.184 | | 1.181 | 1.181 | 1.180 | 1.180 | | |
| K | 0.558 | 0.578 | | 0.572 | 0.572 | 0.572 | 0.572 | | |
| L | 1.174 | 1.184 | | 1.181 | 1.181 | 1.180 | 1.180 | | |
| M | 1.365 | 1.375 | | 1.373 | 1.370 | 1.370 | 1.370 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| O | 4.119 | 4.129 | | 4.126 | 4.126 | 4.126 | 4.125 | | |
| P | 0.115 | 0.135 | | 0.126 | 0.126 | 0.125 | 0.124 | | |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.132 | | |
| R | 0.240 | 0.260 | | 0.254 | 0.254 | 0.254 | 0.256 | | |
| S | 0.115 | 0.135 | | 0.124 | 0.124 | 0.124 | 0.125 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 3.210 | 3.250 | | 3.233 | 3.233 | 3.233 | 3.232 | | |
| V | 0.230 | 0.250 | | 0.242 | 0.242 | 0.242 | 0.250 | | |
| W | 0.115 | 0.135 | | 0.125 | 0.128 | 0.125 | 0.128 | | |
| X | 0.307 | 0.312 | | 0.310 | 0.310 | 0.312 | 0.310 | | |
| Y | 0.760 | 0.765 | | 0.760 | 0.760 | 0.763 | 0.760 | | |
| Z | 0.352 | 0.372 | | 0.363 | 0.363 | 0.367 | 0.363 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.628 | 0.625 | 0.629 | 0.628 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.060 | | |
| AD | 0.240 | 0.260 | | 0.252 | 0.252 | 0.251 | 0.252 | | |
| AE | 1.500 | 1.520 | | 1.512 | 1.510 | 1.510 | 1.506 | | |
| AF | 0.115 | 0.135 | | 0.135 | 0.135 | 0.125 | 0.125 | | |
| AG | 0.240 | 0.280 | | 0.253 | 0.253 | 0.253 | 0.253 | | |
| AH | 0.240 | 0.260 | | 0.252 | 0.252 | 0.255 | 0.251 | | |
| AI | 2.000 | 2.020 | | 2.000 | 2.000 | 2.000 | 2.000 | | |
| AJ | 0.023 | 0.043 | | 0.025 | 0.025 | 0.025 | 0.025 | | |
| Accept/Reject | | | | | | | | | |

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|--------------|----------|
| Measured by: | J.F. 158 |
| Date: | 07/01/18 |

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|-------------|----------|
| Audited by: | CMR |
| Date: | 07/01/22 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.27 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

| | | |
|---|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 30215 |
| Description: Saddle, Aft Inboard | Part Number: | D2574 |
| Inspection Dwg: D2574 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|--------|--------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | DT8682 | 0.440" | 0.440" | 0.440" | 0.440" | | |
| B | 1.745 | 1.755 | | 1.751" | 1.751" | 1.751" | 1.751" | | |
| C | 3.495 | 3.505 | | 3.500" | 3.500" | 3.500" | 3.500" | | |
| D | 1.745 | 1.755 | | 1.751" | 1.751" | 1.751" | 1.751" | | |
| E | 7.990 | 8.010 | | 8.001" | 8.002" | 8.002" | 8.000" | | |
| F | 0.490 | 0.510 | | .498" | .494" | .496" | .496" | | |
| G | 0.257 | 0.262 | DT8683 | 0.260" | 0.260" | 0.260" | 0.260" | | |
| H | 0.375 | 0.380 | DT8684 | 0.376" | 0.376" | 0.376" | 0.376" | | |
| I | 0.490 | 0.510 | | .499" | .500" | .499" | .501" | | |
| J | 1.174 | 1.184 | | 1.181" | 1.181" | 1.181" | 1.181" | | |
| K | 0.558 | 0.578 | | .568" | .567" | .568" | .570" | | |
| L | 1.174 | 1.184 | | 1.181" | 1.181" | 1.181" | 1.181" | | |
| M | 1.365 | 1.375 | | 1.372" | 1.372" | 1.372" | 1.372" | | |
| N | 2.495 | 2.505 | | 2.500" | 2.500" | 2.500" | 2.500" | | |
| O | 4.119 | 4.129 | | 4.124" | 4.124" | 4.124" | 4.124" | | |
| P | 0.115 | 0.135 | | .124" | .125" | .126" | .127" | | |
| Q | 0.115 | 0.135 | | .135" | .135" | .135" | .135" | | |
| R | 0.240 | 0.260 | | .253" | .254" | .256" | .256" | | |
| S | 0.115 | 0.135 | | .123" | .123" | .127" | .123" | | |
| T | 0.178 | 0.198 | | .188" | .188" | .188" | .188" | | |
| U | 3.210 | 3.250 | | 3.233" | 3.233" | 3.233" | 3.232" | | |
| V | 0.230 | 0.250 | | .237" | .239" | .237" | .237" | | |
| W | 0.115 | 0.135 | | .131" | .131" | .130" | .122" | | |
| X | 0.307 | 0.312 | | .312" | .312" | .312" | .312" | | |
| Y | 0.760 | 0.765 | | .762" | .763" | .763" | .763" | | |
| Z | 0.352 | 0.372 | | .365" | .370" | .370" | .370" | | |
| AA | 0.470 | 0.530 | | .500" | .500" | .500" | .500" | | |
| AB | 0.615 | 0.635 | | .627" | .627" | .626" | .627" | | |
| AC | 0.053 | 0.073 | | .063" | .063" | .063" | .063" | | |
| AD | 0.240 | 0.260 | | .249" | .254" | .251" | .249" | | |
| AE | 1.500 | 1.520 | | 1.504" | 1.512" | 1.512" | 1.512" | | |
| AF | 0.115 | 0.135 | | .135" | .135" | .135" | .135" | | |
| AG | 0.240 | 0.280 | | .255" | .256" | .265" | .265" | | |
| AH | 0.240 | 0.260 | | .251" | .256" | .251" | .252" | | |
| AI | 2.000 | 2.020 | | 2.004" | 2.004" | 2.004" | 2.004" | | |
| AJ | 0.023 | 0.043 | | .025" | .025" | .025" | .025" | | |
| Accept/Reject | | | | | | | | | |

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| Measured by: | J.F. |
| Date: | 07/01/19 |

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| Audited by: | JML |
| Date: | 07/01/22 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.27 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

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|---|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 30215 |
| Description: Saddle, Aft Inboard | Part Number: | D2574 |
| Inspection Dwg: D2574 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

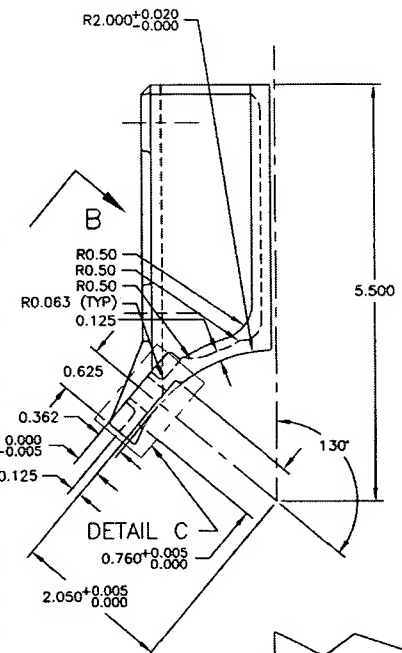
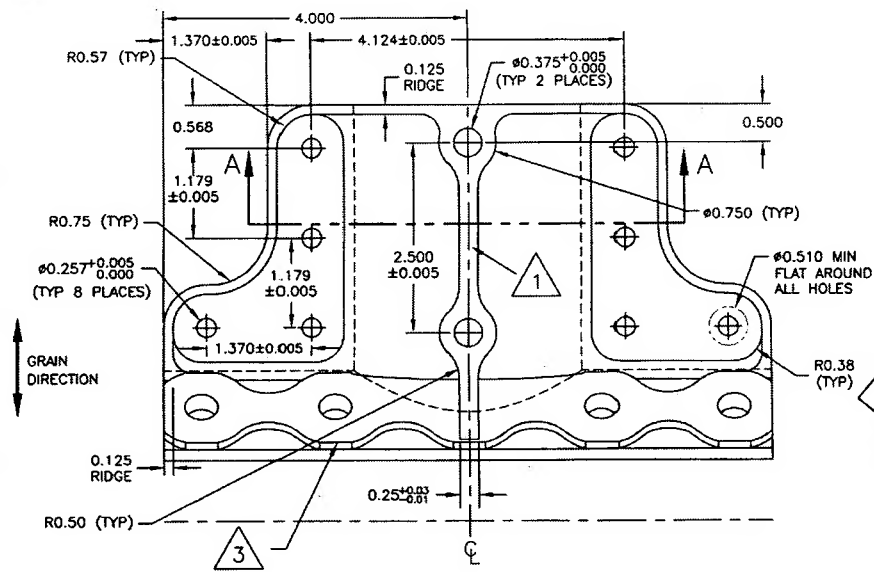
| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | DT8682 | .439 | .438 | .438 | .438 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.751 | 1.751 | 1.751 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.501 | 3.501 | 3.501 | | |
| D | 1.745 | 1.755 | | 1.751 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 8.003 | 8.002 | 8.002 | 8.002 | | |
| F | 0.490 | 0.510 | | .496 | .496 | .497 | .497 | | |
| G | 0.257 | 0.262 | DT8683 | .254 | .258 | .258 | .258 | | |
| H | 0.375 | 0.380 | DT8684 | .376 | .376 | .376 | .377 | | |
| I | 0.490 | 0.510 | | .505 | .505 | .505 | .506 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.180 | 1.181 | | |
| K | 0.558 | 0.578 | | .570 | .570 | .570 | .570 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.180 | | |
| M | 1.365 | 1.375 | | 1.370 | 1.370 | 1.370 | 1.370 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.501 | | |
| O | 4.119 | 4.129 | | 4.122 | 4.122 | 4.122 | 4.123 | | |
| P | 0.115 | 0.135 | | .126 | .126 | .126 | .126 | | |
| Q | 0.115 | 0.135 | | .126 | .126 | .126 | .125 | | |
| R | 0.240 | 0.260 | | .253 | .253 | .252 | .253 | | |
| S | 0.115 | 0.135 | | .126 | .126 | .121 | .125 | | |
| T | 0.178 | 0.198 | | .188 | .188 | .188 | .189 | | |
| U | 3.210 | 3.250 | | 3.228 | 3.228 | 3.228 | 3.228 | | |
| V | 0.230 | 0.250 | | .250 | .250 | .250 | .250 | | |
| W | 0.115 | 0.135 | | .120 | .120 | .120 | .121 | | |
| X | 0.307 | 0.312 | | .310 | .310 | .311 | .312 | | |
| Y | 0.760 | 0.765 | | .760 | .760 | .762 | .762 | | |
| Z | 0.352 | 0.372 | | .362 | .363 | .363 | .363 | | |
| AA | 0.470 | 0.530 | | .500 | .500 | .500 | .500 | | |
| AB | 0.615 | 0.635 | | .625 | .625 | .617 | .617 | | |
| AC | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | | |
| AD | 0.240 | 0.260 | | .250 | .255 | .255 | .255 | | |
| AE | 1.500 | 1.520 | | 1.512 | 1.512 | 1.511 | 1.512 | | |
| AF | 0.115 | 0.135 | | .120 | .125 | .125 | .120 | | |
| AG | 0.240 | 0.280 | | .250 | .255 | .255 | .255 | | |
| AH | 0.240 | 0.260 | | .250 | .255 | .255 | .255 | | |
| AI | 2.000 | 2.020 | | 2.002 | 2.002 | 2.002 | 2.002 | | |
| AJ | 0.023 | 0.043 | | .031 | .037 | .037 | .037 | | |
| Accept/Reject | | | | | | | | | |

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|--------------|-------------|
| Measured by: | J.F. / J.F. |
| Date: | 07/01/21 |

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|-------------|----------|
| Audited by: | J.M. |
| Date: | 07/01/22 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.27 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

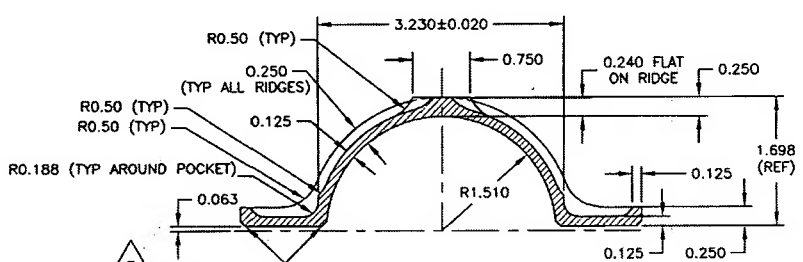
RELEASED
05.12.06



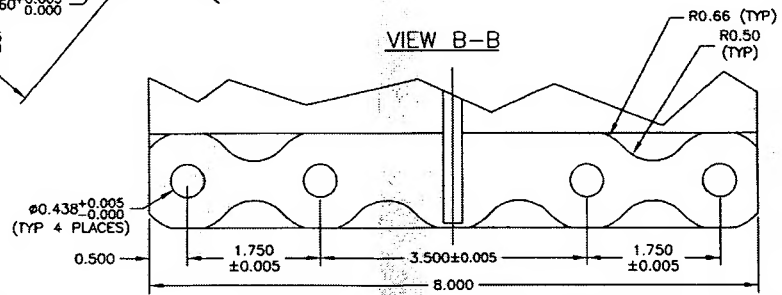
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

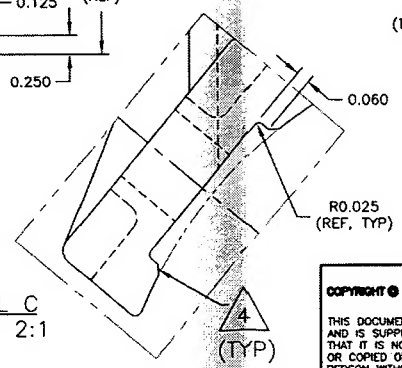
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



SECTION A-A



VIEW B-B



DETAIL C
SCALE 2:1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30215

| | | |
|---------|----------|--|
| E | 05.07.13 | ADD CHAMFER ON RIDGE NOTE 4 |
| D | 02.09.06 | ADD RIDGES; TIGHTEN TOLERANCES |
| C | 99.10.22 | INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177 |
| B | 96.12.02 | ADD GRAIN DIR., 0.438 WAS 0.425 |
| A | 96.09.16 | NEW ISSUE |
| DESIGN | DS | DRAWN BY PH |
| CHECKED | PH | APPROVED |
| DATE | 05.07.13 | TITLE |
| | | DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA |
| | | DRAWING NO. D2574 |
| | | SCALE 2:3 |
| | | REV. E SHEET 1 OF 1 |

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